

Work Order ID 60384

July 7, 2010 8:35:17 AM

Page 1

Item ID: D3773-041

Revision ID:

Item Name: Headrest Assembly

Start Date: 7/07/10 Start Qty: 10.00

Required Date: 7/16/10 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *CY*
QC:

Date: *10/7/7* Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Sequence ID/
Work Center ID Operation
Description

Draw Nbr	Revision Nbr
D3773	Rev B

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

- 1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 ****take dowel pin out before welding****
- 2- weld as per dwg D3773 QSI004
- 316 S.S. Welding Rod Batch: *M109213*
- 3- if necessary grind interior of D3773-3 leg flush after welding

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solo 1/2

Accept



Setup Start



Stop



Run Start



Stop



Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Pl 10.07.22

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60384

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Item ID: D3773-041

Revision ID:

Item Name: Headrest Assembly

Start Date: 7/07/10

Start Qty: 10.00

Required Date: 7/16/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(10)

10.07.20

140



Packaging

Packaging

Identify as per dwg & Stock Location: 248

Memo

0.00

0.00

10.7-23

(10)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/07/2010
MF 10-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 7, 2010 8:35:15 AM

Work Order ID: 60384

Parent Item: D3773-041

Parent Item Name: Headrest Assembly

Page 1

Start Date: 7/07/10

Start Qty: 10.00

Required Date: 7/16/10

Required Qty: 10.00

Comments:

IPP Rev:A 08-05-21 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name

Replacement Item ID

Mfg/ Purch

Bin Item

Primary Location

Last Location

Route Seq ID

Unit of Measure

Qty on Hand

Qty per Kit

Total Qty

Qty Issued

Date Issued

Status

D3773-1



Adapter

Manufactured No

110

Each

2.0000

1

10



Pl 10.07.21

B60385 → 10

D3773-3



Leg

Manufactured No

54799

110

Each

1.0000

1

10



Pl 10.07.21

B60386 → 10

Location

WA

Loc Qty

2

Loc Code

Location

WA

Loc Qty

1

Loc Code

56862

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

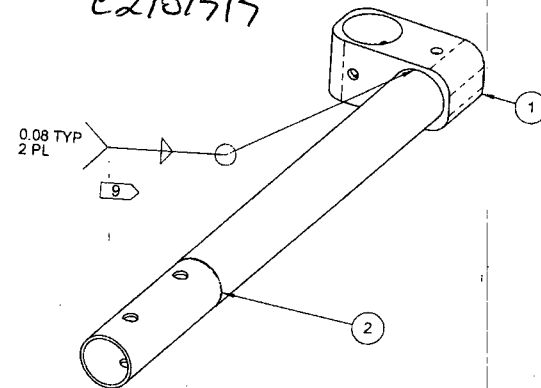
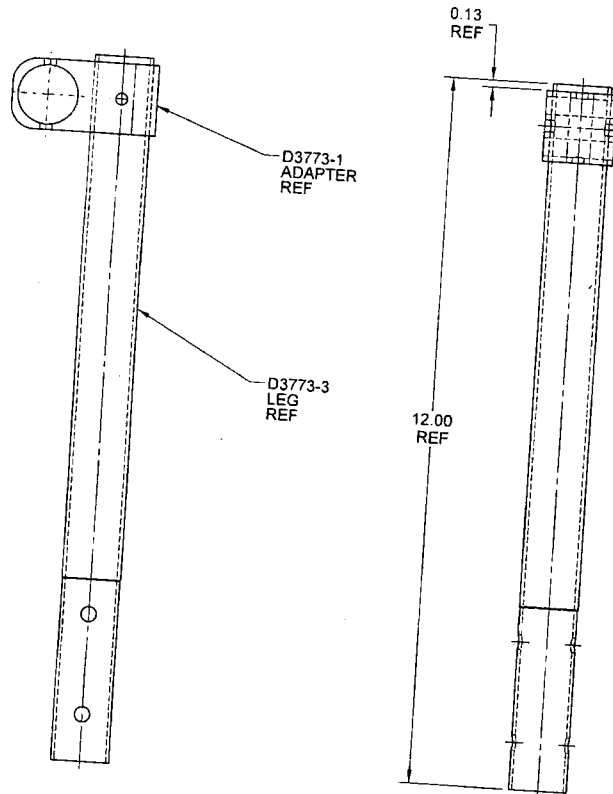
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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WORK ORDER
NO. 60384
e2101717



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

- NOTES:
- 1) MATERIAL: SEE D3773-1/-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
 - 8) WELD: PER DART QSI 004
 - 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

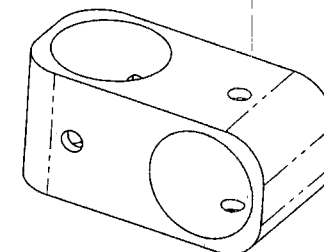
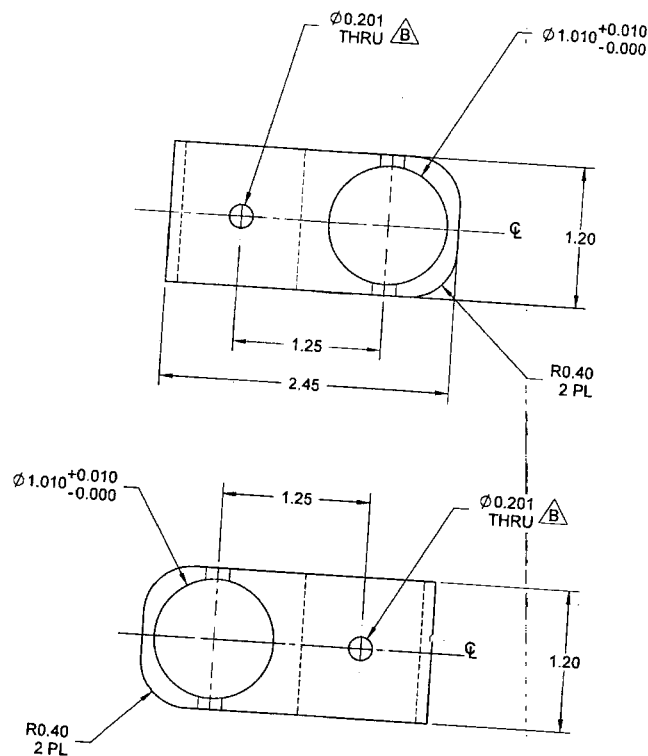
D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED	HS		
MFG. APPR.	HS		
APPROVED	HS		
DE APPR.	HS		
DATE	08.06.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3773** REV. B
TITLE **HEADREST ADAPTER** SCALE NTS
SHEET 1 OF 3

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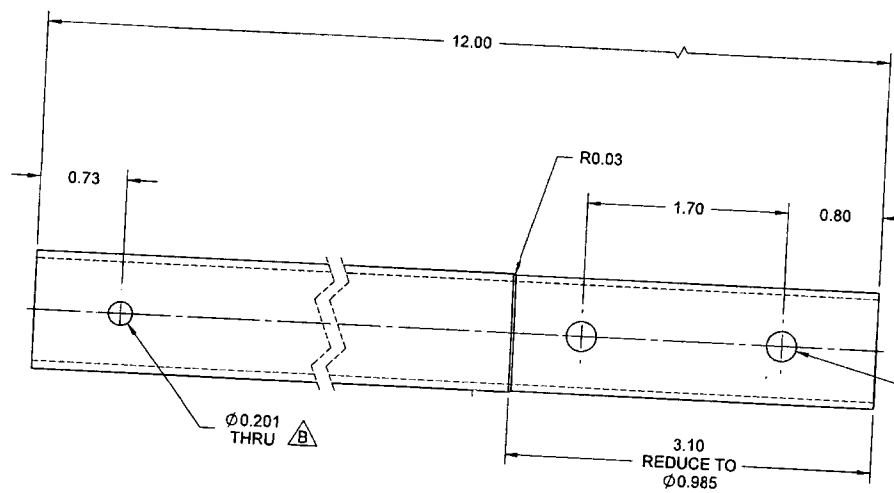
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NO. 60384

D3773-1 ADAPTER

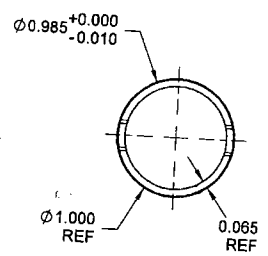
NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3773 TITLE HEADREST ADAPTER SCALE NTS REV. B SHEET 2 OF 3 COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
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CHECKED		
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DE APPR.		
DATE	08.06.24	



D3773-3 LEG



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NO. 60384

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

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CHECKED	HS	SHEET 3 OF 3		
MFG. APPR.	HS	TITLE HEADREST ADAPTER		
APPROVED	HS	SCALE NTS		
DE APPR.	HS	DATE 08.06.24		

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